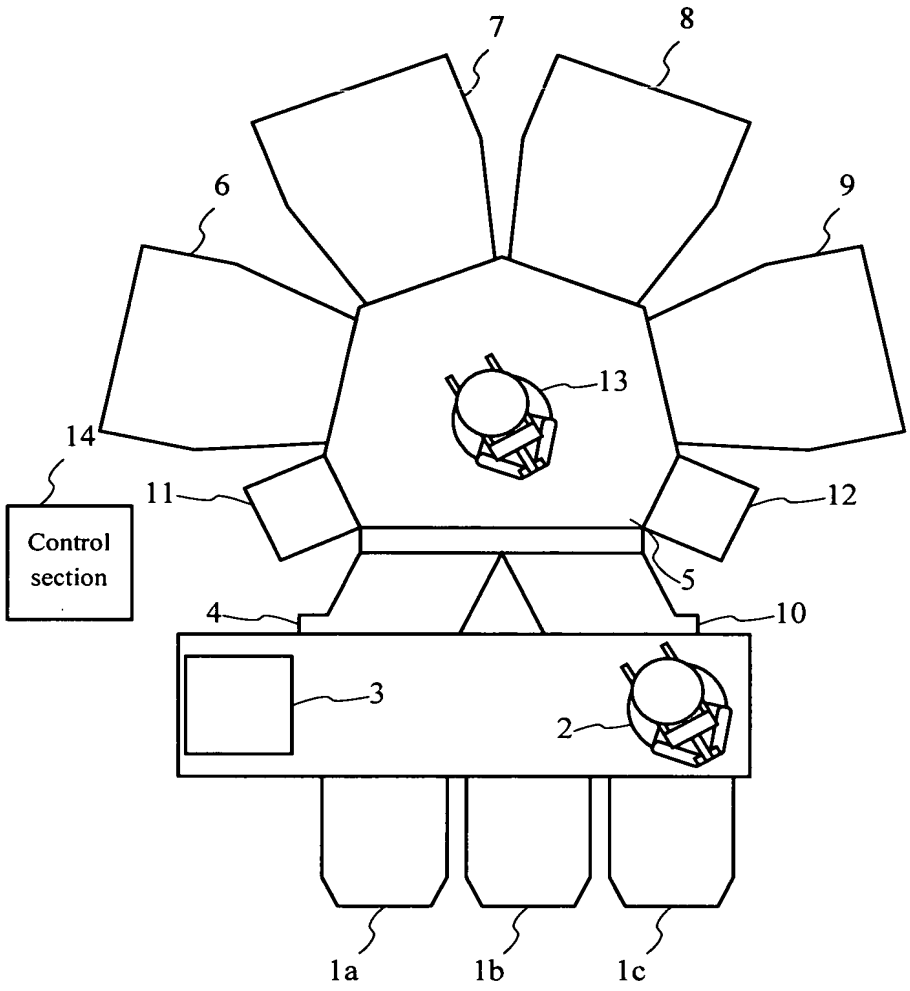
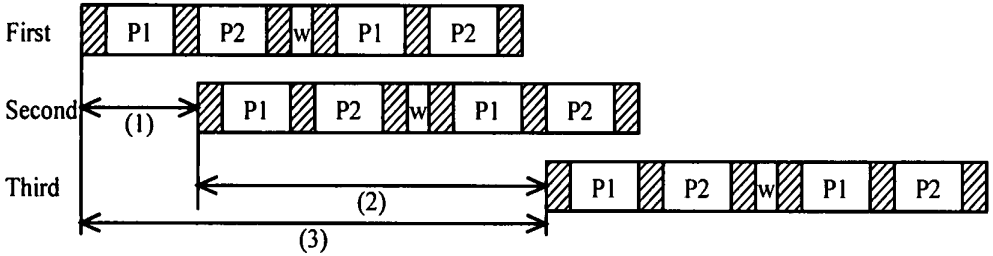


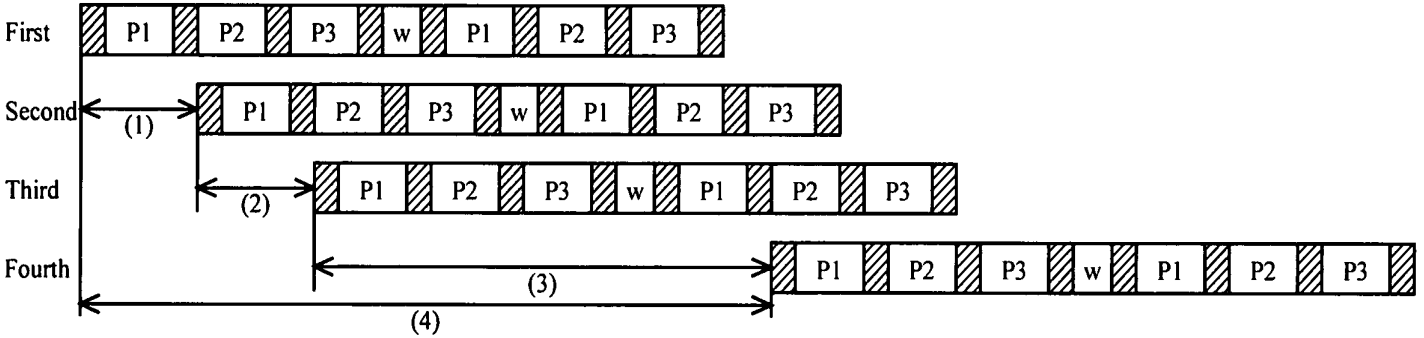
Fig.1

(A) When the number of continuous processes is two



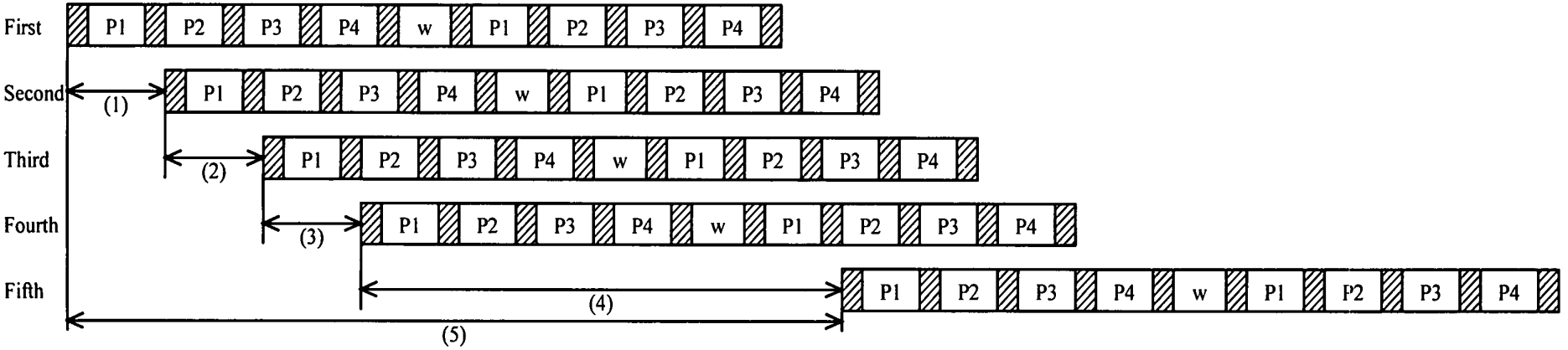
Cycle time when the number of continuous processes is two : CT1'=(3)/2=(4P+8T)/2

(B) When the number of continuous processes is three



Cycle time when the number of continuous processes is three : CT2'=(4)/3=(6P+12T)/3

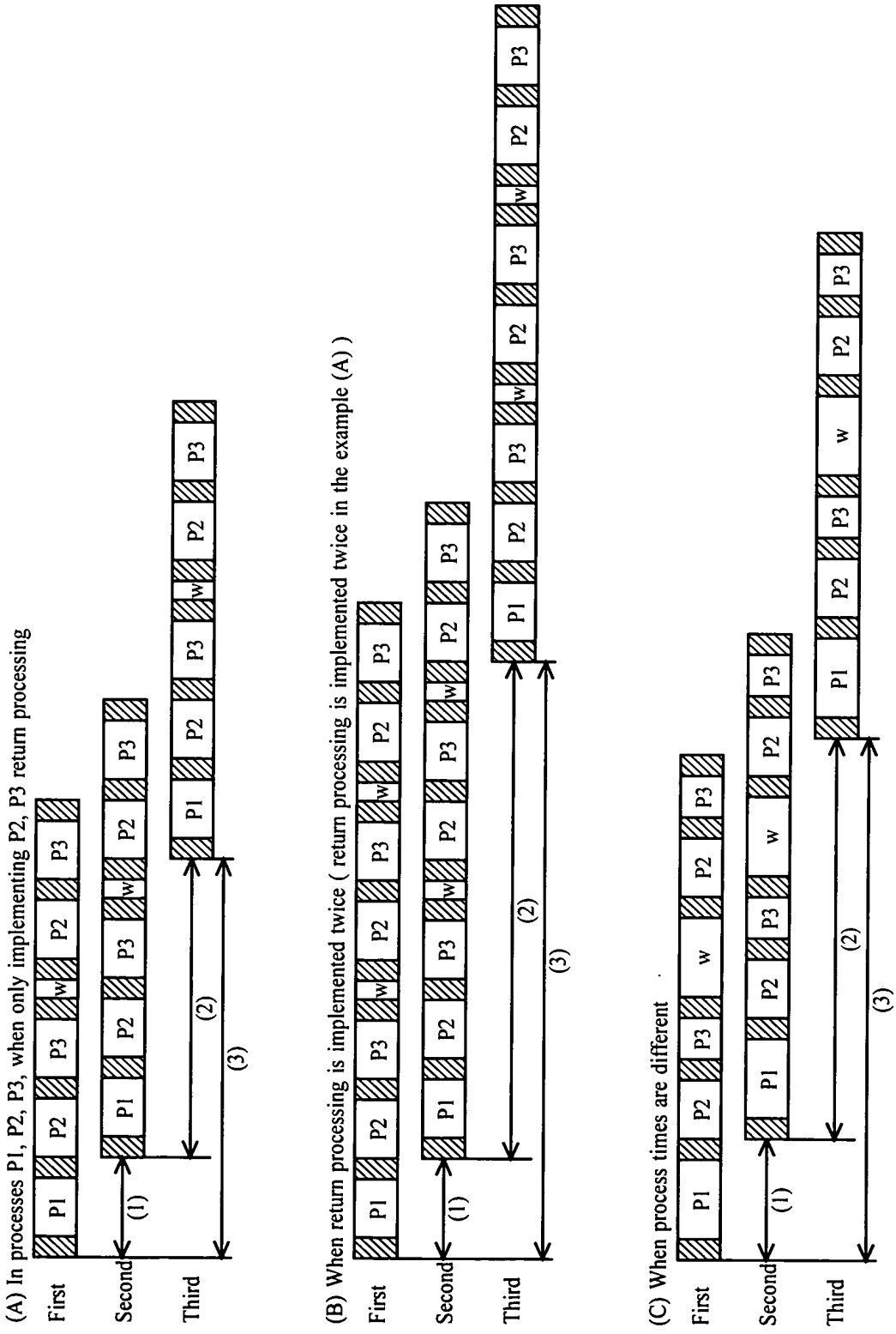
(C) When the number of continuous processes is four



Cycle time when the number of continuous processes is four : CT3'=(5)/4=(8P+16T)/4

Fig.2

Fig.3


(A) In processes P1, P2, P3, when only implementing P2, P3 return processing
First
Second
Third
P1
P2
P3
w
(1)
(2)
(3)
(B) When return processing is implemented twice (return processing is implemented twice in the example (A))
First
Second
Third
P1
P2
P3
w
(1)
(2)
(3)
(C) When process times are different
First
Second
Third
P1
P2
P3
w
(1)
(2)
(3)

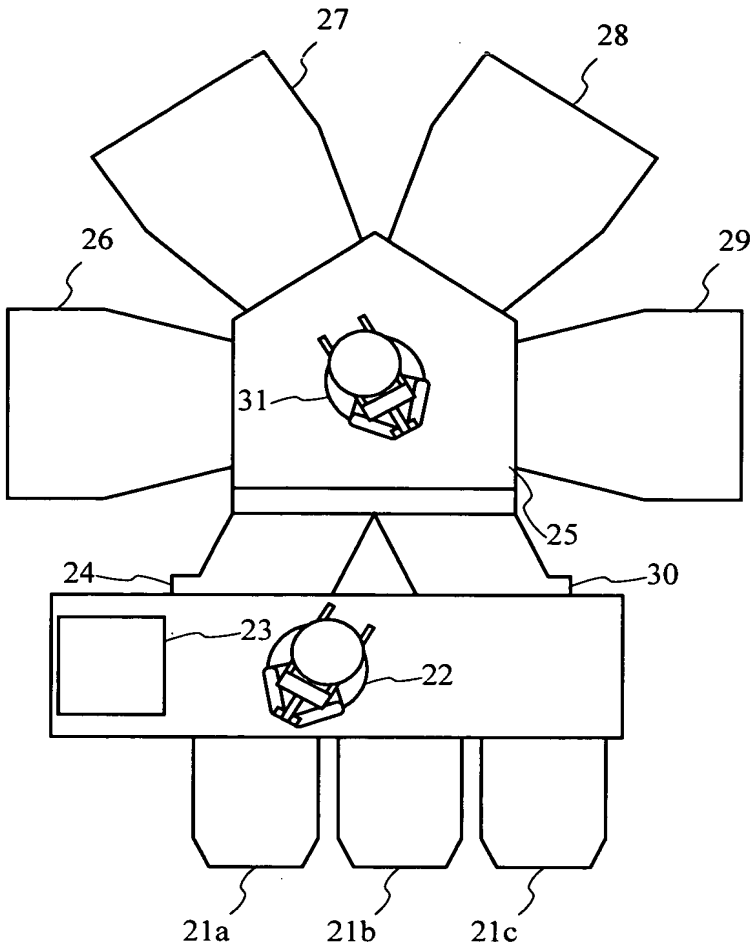


Fig.4

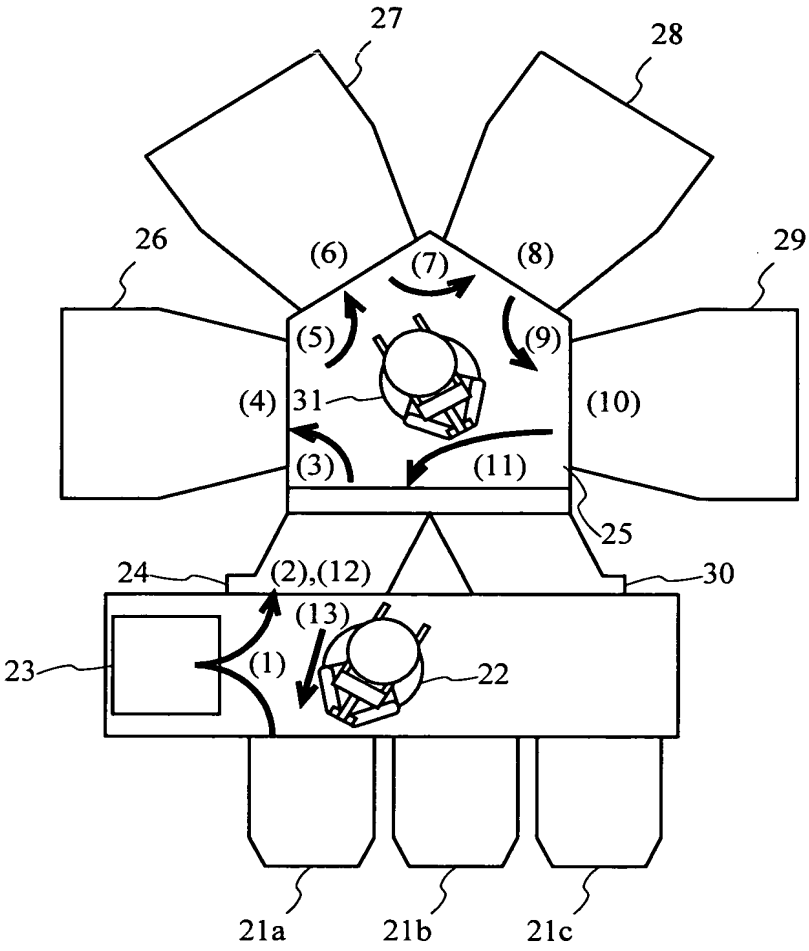
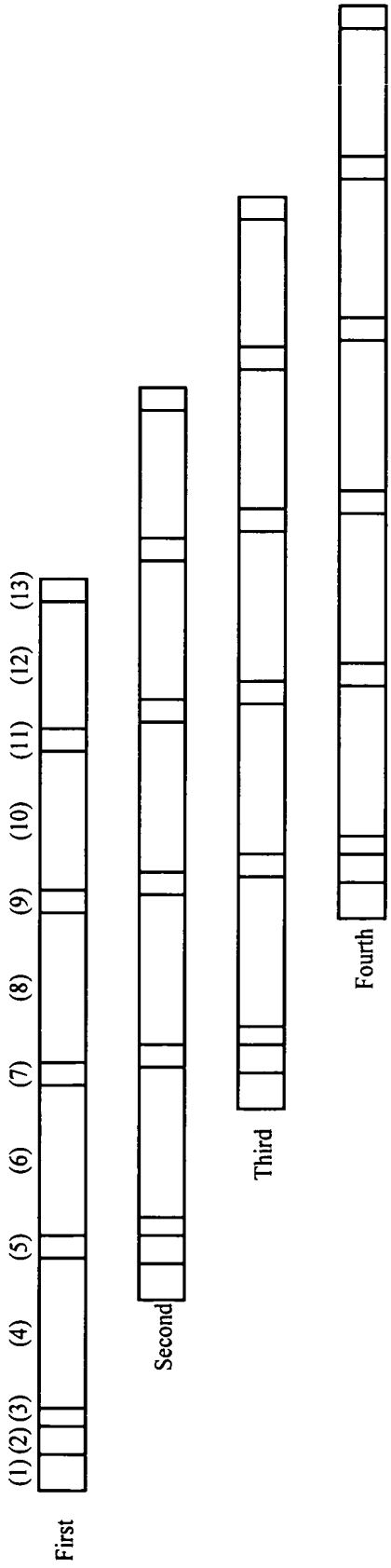


Fig.5

Fig.6



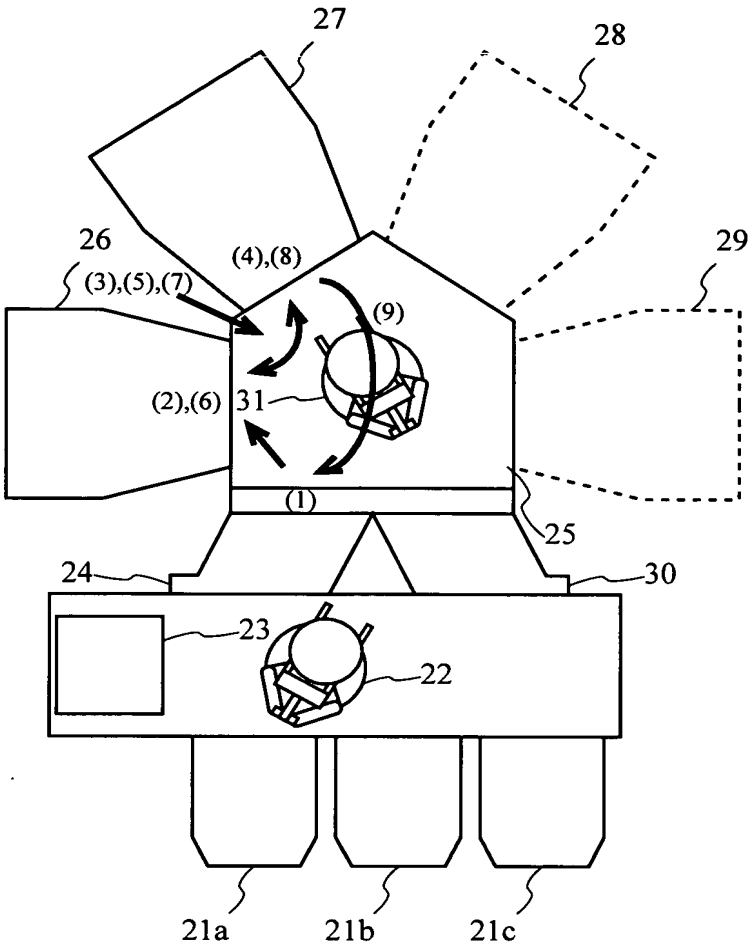
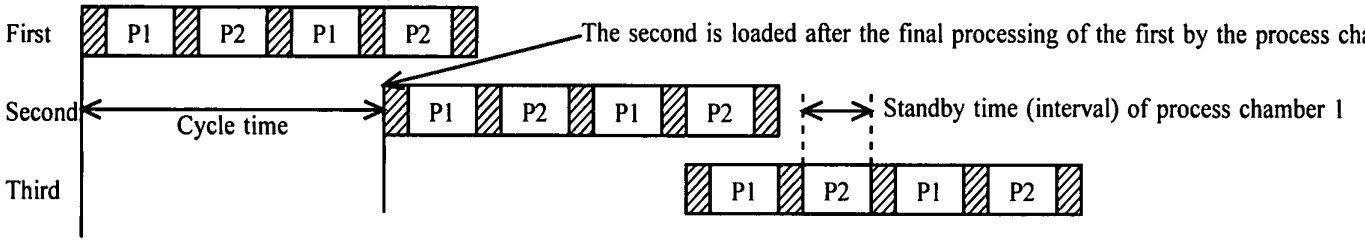


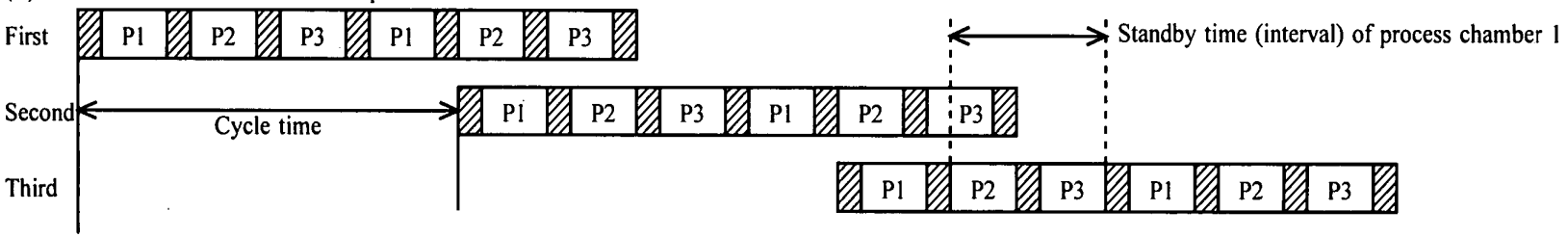
Fig.7

(A) When the number of continuous processes is two



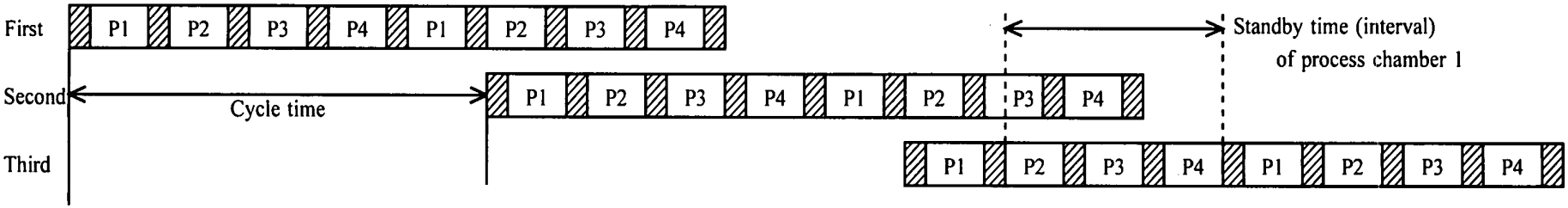
Cycle time when the number of continuous processes is two : CT1=3P+4T

(B) When the number of continuous processes is three



Cycle time when the number of continuous processes is three : CT2=4P+5T

(C) When the number of continuous processes is four



Cycle time when the number of continuous processes is four : CT3=5P+6T

Fig.8